

Date: Monday, 2/4/2008 11:23:16 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 37153	
Estimate Number : 10271	
P.O. Number :	Part Number : D2561
This Issue : 2/4/2008 S.O. No. :	Drawing Number : D2561 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 34357	Material :
Written By :	Due Date : 2/11/2008 Qty: 60 Um: Each
Checked & Approved By : <u>080204</u>	
Comment : Est C 00.05.19 Added inspect level 8 EC	
Est Rev:D Now on Waterjet 06-06-14 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0250X06000	6061-T6 Bar .25" x 6.0"
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Comment: Qty.: 0.3850 f(s)/Unit Total : 23.1021 f(s)  
 Material: 6061-T6, or 5052-H34 6.00" x 0.25" Thick  
 Batch: 100782 1B 8-2-4  
103433X16

70

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2561  
 Dwg Rev: B 8-2-4  
 Prog Rev: B

2-Deburr if necessary 8-2-5

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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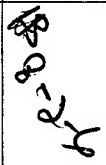
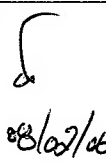
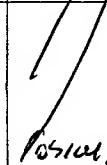

Comment: SMALL & MEDIUM FAB RESOURCE 1  
 Deburr, no sharp edges

5.1 Inspect QC #5.

08/02/06 70 68  
 08/02/06 70 68

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 08/02/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/08	11 20	<del>Part scrap</del> due to water jet causing a large cut into the part RL still pressure in water jet as it moved across the part.	 10/01/08	Scrap and destroy no replace qty 	 08/02/08	 08/02/08	 10/01/08	 08/02/08

NOTE: Date & initial all entries

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Drawing Name: LUG

Job Number: 37153

Part Number: D2561

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: PAT E

AS 08/02/07

(XZ)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



(69)

Comment: FINAL INSPECTION/W/O RELEASE

208102/08

Job Completion



mi 2008/2/07

(69)

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

X	First Article	Prototype
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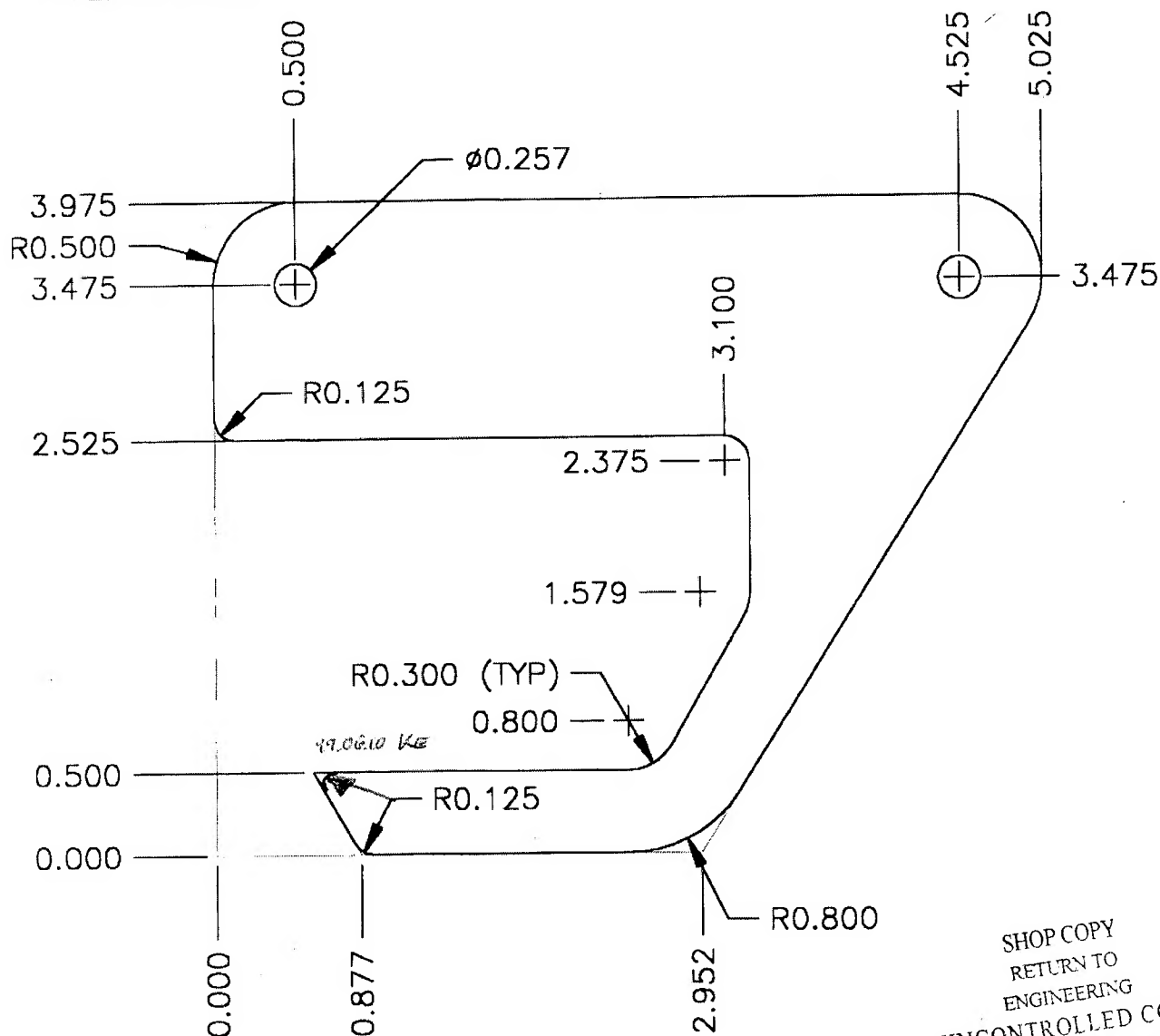
Measured by: <b>IB</b>	Audited by: <b>[Signature]</b>	Prototype Approval:	N/A
Date: <b>8-2-4</b>	Date: <b>08/02/15</b>	Date:	

H:\FORMS\Quality Assurance\approved QA\FAI revD



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2561	SHEET 1 OF 1
DATE		TITLE	SCALE
96.04.26		LUG PLATE	1:1

RELEASED  
96 05 06



MATERIAL: 6061-T6 0.25 THICK  
OR 6063-T6 0.25 THICK  
OR 5052-H34 0.25 THICK

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37153